

Work Order ID **55875**

February 3, 2010 1:41:38 PM

Page 1

Item ID: D4008-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Fuel Filler Splash Guard Assembly

Start Date: 2/03/10

Start Qty: 1.00

Cust Item ID:

Required Date: 2/03/10

Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 10-2-03

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4008

A-PRELIM

Rev. A

0.00

10 MAT NOT PULLED

100



Waterjet

0.00

B 10-2-4

FLOW CNC Waterjet

Memo

1-Cut as per Dwg (D4008-1)

Dwg Rev: 005

Prog Rev: 11m

2-Deburr if necessary

(2)

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

B 10-2-4

PRELIMINARY ISSUE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 55875

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Page 2

Item ID: D4008-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Fuel Filler Splash Guard Assembly

Start Date: 2/03/10 Start Qty: 1.00

Cust Item ID:

Required Date: 2/03/10 Req'd Qty: 1.00

Customer:




Reference:

Run Start

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	⇒ Sid 2/03			(42)			
130  Brake NC Brake NC	Bend as per dwg Memo Bend D4004-1 as per Dwg	0.00 0.00	SPB 10/02/09			(2)			
140  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	⇒ Sid 2/03			(42)			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Work Order ID 55875

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Page 3

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Item Name: Fuel Filler Splash Guard Assembly

Start Date: 2/03/10 Start Qty: 1.00

Cust Item ID:

Required Date: 2/03/10 Req'd Qty: 1.00

Customer:

Reference:

Run Start

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

Chemical Conversion Coat per QSI005 4.1

0.00

OK 10-02-10

2



HandFinish

Memo

0.00

Hand Finishing

160

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

⇒ 10/02/16



Powdercoat

Memo

0.00

START: 2:00pm
Temp: 320°F
Flu: 2:30pm

12

Powder Coating

170

QC3- Inspect Part Finish

0.00

OK 10-02-17

2



QC

Memo

0.00

Quality Control

POSITIVE RECAL.

EFFECTIVE 10.07.26 AUTH

RELEASED DATE 10.07.26

See prelim.

Qty 2

WIO: 55875

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10A-26	160	Paints are to be grey per drawing. Perm change	ALPERRY DOW	10/12/16		10A-26	10A-26

Part No: D4008-041 PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: / Date: 10/12/16
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10A-26	160	Parts are powder coated. White. i should be grey per drawing rev. A. be. no instructions. ② Preliminary stage.	10/10/12	Sand & strip to remove white powder coat. re-plate per QSI WOS. to plate	10/10/12	10/12/15	10/10/12	10A-26
			10/10/12	M112 588 P/C Grey per Dwg Start 8:45 Finish 9:15 Temp 320	10/10/12	10/12/15	10/10/12	10/12/15

NOTE: Date & initial all entries

Work Order ID 55875

February 3, 2010 1:41:38 PM



Page 4

Item ID: D4008-041

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Setup Start



Revision ID:

Stop



Item Name: Fuel Filler Splash Guard Assembly

Start Date: 2/03/10 Start Qty: 1.00



Cust Item ID:

Required Date: 2/03/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

180

0.00



Small Fab

Memo

0.00

Small Fab

Assemble as per dwg

10/12/15 (2)

190

0.00



QC

Memo

0.00

Quality Control

QC5- Inspect part completeness to step on W/O

Solizli-

Inspector b Rev A
Dwg.

②

200

0.00



Packaging

Memo

0.00

Packaging

Identify as per dwg & Stock Location: 111

10/12/15 (2) SF

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 5

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Start Date: 2/03/10 Start Qty: 1.00



Cust Item ID:

Required Date: 2/03/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/12/16

MF

10-12-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

February 3, 2010 1:41:41 PM

Page 1

Work Order ID: 55875



Parent Item: D4008-041



Parent Item Name: Fuel Filler Splash Guard Assembly

Start Date: 2/03/10

Required Date: 2/03/10

Comments: IPP rev A 10.01.27 New issue Prelim EC verified by:DD

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

M2024T3S.032

Purchased

No

sf

208.5254

0.2879

16



18 10-2-4

2024-T3 .032 sheet

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT 15031

208.5254316

15031

102942

1.5

105555

4.0684

106272

5.3

108595

1.2

109240

6.6032

110305

88.49

110778

18.0296316

111699

11.3342

113189

69

18147

3

D3941

Manufactured No

f

64.3400

0.2211



Rubber Cushion

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

64.34

48512

64.34

0.4422

cut 1.25" long

D4008-5

Manufactured No

Each

0.0000

1.0000



Fuel Filler Splash Guard Hinge Half

B64629 (2x)

ES 10/12/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 2

February 3, 2010 1:41:41 PM

Work Order ID: 55875



Parent Item: D4008-041



Parent Item Name: Fuel Filler Splash Guard Assembly

Start Date: 2/03/10

Required Date: 2/03/10

Comments: IPP rev A 10.01.27 New issue Prelim EC verified by:DD

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D4008-9 		Manufactured	No				Each	0.0000	1.0000			
Spring D4008-7 		Manufactured	No				Each	0.0000	2.0000			
Washer MS20470AD3-3 		Purchased	No				Each	8,474.000	5.0000			
Rivet,Universal Head												

B55193
B59462 (W)
Ep 510/12/15
Ep 510/12/15
Ep 510/12/15

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

8474

1065

1435

16941 ✓

7039

15036

10
~~10~~

February 3, 2010 1:41:41 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

February 3, 2010 1:41:41 PM

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Parent Item: D4008-041



Parent Item Name: Fuel Filler Splash Guard Assembly

Start Date: 2/03/10

Required Date: 2/03/10

Comments: IPP rev A 10.01.27 New issue Prelim EC verified by:DD

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21042L08		Purchased	No				Each	650.0000	2.0000			
Nut												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

650

110002

24

111889

30

112243

43

112492

24

112612

1

112794

8

113595

120

113749

400

MS35206-S245

Purchased

No



Screw

NAS1149DN832J

Purchased

No



WASHER

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

113

111193

3

111359

30

112385

80

Each

0.0000

2.0000

M113898 (42)



Each

113.0000

6.0000



M116391 (122)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

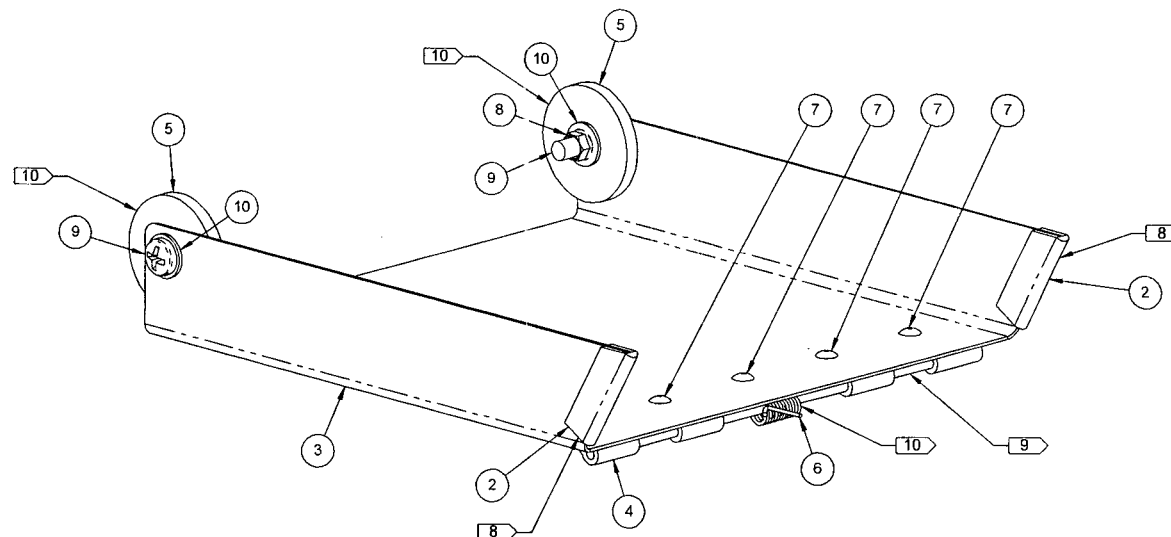
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER
1	X	D4008-041	FUEL FILLER SPLASH GUARD ASSEMBLY	JCA-M47-2-26
2	2	D3941-1	RUBBER CUSHION	
3	1	D4008-1	FUEL FILLER SPLASH GUARD CHANNEL	
4	1	D4008-5	HINGE	
5	2	D4008-7	WASHER	
6	1	D4008-9	SPRING	
7	5	MS20470AD3-3	RIVET ✓	
8	2	MS21042L08	NUT ✓	
9	2	MS35206S245	SCREW ✓	
10	6	NAS1149DN832J	WASHER ✓	

SHOP
RETURN
ENGINEERING
UNCONTROLLED
SUBJECT TO APPROVAL
WITHOUT NOTICE
WORK ORDER
NO. 55825

PA10-2-03



D4008-041 FUEL FILLER SPLASH GUARD ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4008-041" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.13 lbs
- 8) ATTACH D3941-1 RUBBER CUSHION USING SILICONE ADHESIVE, TRIM TO FIT, AFTER POWDER COAT
- 9) MASK HINGE PIN AREA BEFORE POWDER COAT
- 10) INSTALL D4008-7 WASHER AND D4008-9 SPRING AFTER POWDER COAT

PRELIMINARY ISSUE

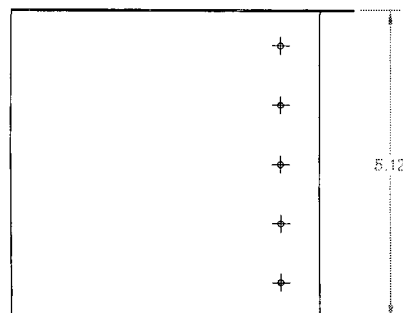
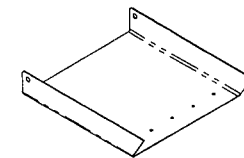
09.10.21

PA1	NEW ISSUE	09.10.21
REV.	DESCRIPTION	BY DATE
DESIGN		
DRAWN		
CHECKED		
MFG. APPR.		
APPROVED		
DE APPR.		
DATE	09.10.21	

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4008	REV. PA1 SHEET 1 OF 9
TITLE SPLASH GUARD	SCALE NTS
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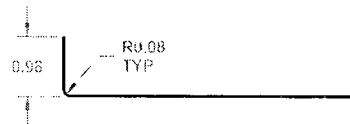
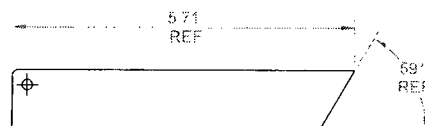
x2

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4008-1	REF JCA-M47-2-26



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 35872

PS-0-2-03



D4008-1 FUEL FILLER SPLASH GUARD CHANNEL

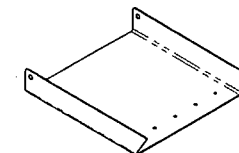
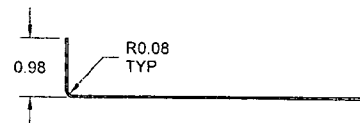
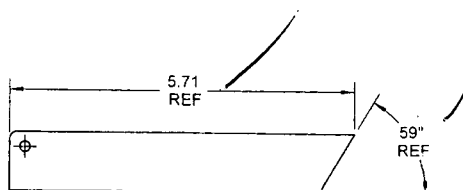
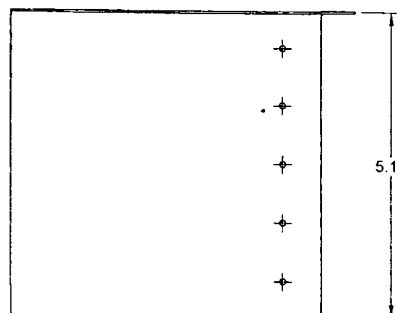
PRELIMINARY ISSUE

09.10.21

- NOTES:
- 1) MATERIAL: MADE FROM D4008-1F
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.09 lbs

DESIGN	<i>JS</i>	DART AEROSPACE LTD	
DRAWN	<i>JS</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>JS</i>	DRAWING NO.	REV. PA1
MFG. APPR.	<i>JS</i>	D4008	SHEET 3 OF 9
APPROVED		TITLE	SCALE
DE APPR.		SPLASH GUARD	NTS
DATE	09.10.21	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4008-1	REF JCA-M47-2-26



D4008-1 FUEL FILLER SPLASH GUARD CHANNEL

RELEASED
2010-05-05
WJ

W/0 55875

NOTES:

- 1) MATERIAL: MADE FROM D4008-1F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.11 lbs

DESIGN	DESIGN	DART AEROSPACE LTD	
DRAWN	DRAWN	HAWKESBURY, ONTARIO, CANADA	
CHECKED	CHECKED	DRAWING NO.	REV. A
MFG. APPR.	MFG. APPR.	D4008	SHEET 3 OF 10
APPROVED	APPROVED	TITLE	SCALE
DE APPR.	DE APPR.	SPLASH GUARD	NTS
DATE	DATE	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
10.02.05	10.02.05	THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

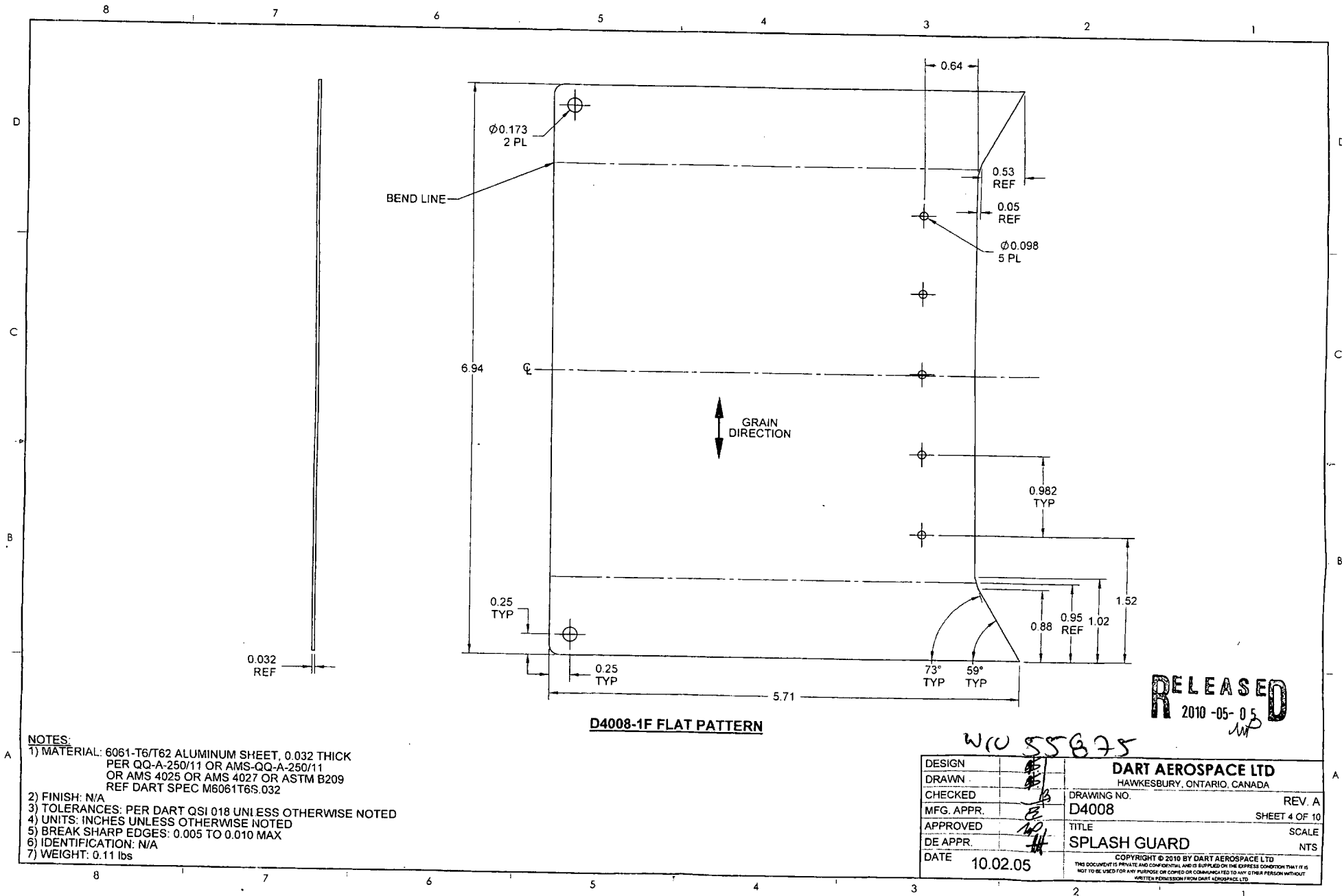
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASED
2010-05-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

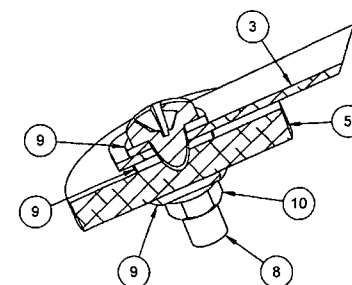
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

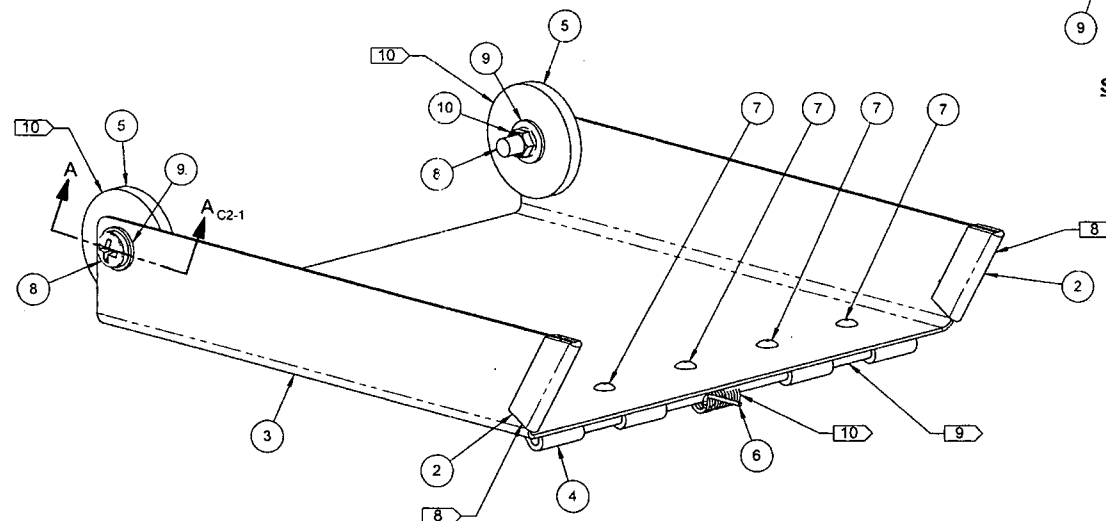
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NOTE: Date & initial all entries

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER
1	X	D4008-041	AUX TANK FILLER SPLASH GUARD ASSEMBLY	JCA-M47-2-26
2	2	D3941-1	RUBBER CUSHION	
3	1	D4008-1	FUEL FILLER SPLASH GUARD CHANNEL	
4	1	D4008-5	HINGE	
5	2	D4008-7	WASHER	
6	1	D4008-9	SPRING	
7	5	MS20470AD3-3	RIVET	
8	2	MS35206S245	SCREW	
9	6	NAS1149DN832J	WASHER	
10	2	MS21042L08	NUT	



SECTION A-A
SCALE: 2X B6-1
TYP



D4008-041 AUX TANK FILLER SPLASH GUARD ASSEMBLY

RELEASED
2010-05-05

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY SANDEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4008-041" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.15 lbs
- 8) ATTACH D3941-1 RUBBER CUSHION USING SILICONE ADHESIVE, TRIM TO FIT, AFTER POWDER COAT
- 9) MASK HINGE PIN AREA BEFORE POWDER COAT
- 10) INSTALL D4008-7 WASHER AND D4008-9 SPRING AFTER POWDER COAT

A		NEW ISSUE		10.02.05	
REV.		DESCRIPTION	BY	DATE	
DESIGN					
DRAWN					
CHECKED					
MFG. APPR.					
APPROVED					
DE APPR.					
DATE	10.02.05				

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4008	REV. A
SHEET 1 OF 10	
TITLE SPLASH GUARD	SCALE NTS
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